

Date: Wednesday, 11/21/2007 12:50:24 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|----------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STOP |
| Job Number | : 35930A | | |
| Estimate Number | : 10731 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D23243 |
| This Issue | : 11/21/2007 S.O. No. : <i>N/A</i> | Drawing Number | : D2324 REV. C |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision | : C |
| Previous Run | : 34291A | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 12/20/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | 20 Um: Each |
| Comment | : Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|-------------------------|
| 1.0 | M6061T6B0750X00750 | 6061-T6 Bar .75" x .75" |
|-----|--------------------|-------------------------|



Comment: Qty.: 0.5565 f(s)/Unit Total : 11.1300 f(s)
 6061-T6 Bar 0.75" x 0.75"

Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)
 (M6061T6B0.750x00.750) Batch: *M106563* *[Signature]* *080114*

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blanks: (0.75" x 0.75") x 5.75" Long Bar

[Signature] *080114*

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio D2324-3 and Dwg D2324
 2- Deburr and Tumble to remove sharp edges
 Identify as D2324-3

Machined Manually

[Signature] *080114*

21

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] *080115*

21

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

[Signature] *080115*

(21)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 35930A

Part Number: D23243

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(21)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BA 08-01-16

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2X)

Comment: INSPECT ALODINE

M-H 08/01/16

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Assy 36748

08/04/16 (21)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/17

Job Completion



U 08-01-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

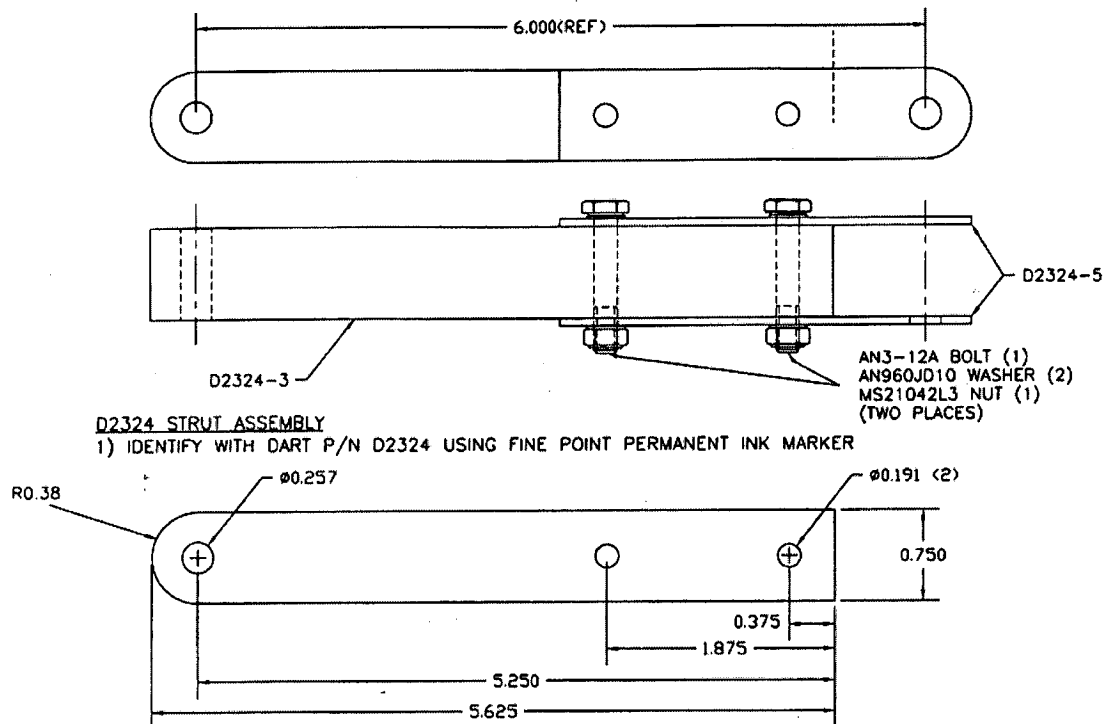

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

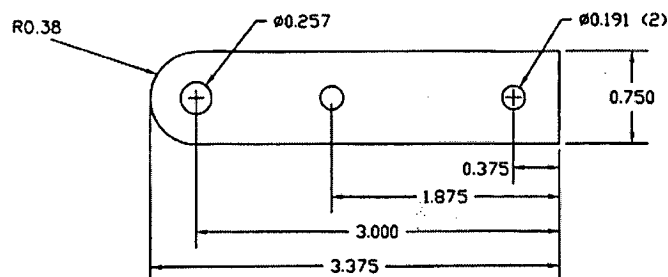
| | | | |
|---|--|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | PH | DRAWING NO. | REV. C |
| CHECKED  | APPROVED  | D2324 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 04.12.14 | STRUT | | |
| A | 94.11.08 | NEW ISSUE | |
| B | 96.05.07 | UPDATE MATERIALS | |
| C | 04.12.14 | UPDATE NOTES | |

RELEASED04.12.16 **D2324 STRUT ASSEMBLY**

- 1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0-750X00:750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35930A